

Work Order ID 123986

September-04-14 11:58:21 AM

Ship ASAP Oct. 16

123986

Page 1

Item ID: D3562-041

Revision ID:

Item Name: Step Weldment

Start Date: 9/04/14 Start Qty: 4.00

Required Date: 9/04/14 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MLJ

Accept

N900040100

Setup Start

NS1

Stop

NS2

4
4

Cust Item ID:

Customer:

QC: _____ Date: _____

SPC (Y/N):

Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3562	F								
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100 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562
2-Deburr and bevel ends for welding

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Quality Control

OCT 14 2014

DAS

24

9-89

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

OCT 15 2014

DAS

24

9-89

Hand Finishing

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube 2403 AS 25-2	General			
	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	
	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

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Item ID: D3562-041

Revision ID:

Item Name: Step Weldment

Start Date: 9/04/14 Start Qty: 4.00

Required Date: 9/04/14 Req'd Qty: 4.00

Reference:

Accept

Split
4
4

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

130

130

QC

Quality Control

Operation
Description

QC7-Inspect Chemical Conversion Coat

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

① 14-10-15 DAS 9 9-13

140

140

Small Fab

Small Fab

0.00

DAS

24

9-89

Small Fab

Memo

0.00

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

*****Ensure to wipe off any excess magnobond *****

A/R Scotch-Weld DP460

Batch: 129294

EXP DATE:

6/15

DQA: _____ Date: _____

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only



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Item ID: D3562-041

Revision ID:

Item Name: Step Weldment

Start Date: 9/04/14 Start Qty: 4.00

Required Date: 9/04/14 Req'd Qty: 4.00

Accept

Split

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

150

150

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID
Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS

43

9-89

OCT 15 2014

160

160

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/Aluminum Rod 1128956

2-Grind end cap welds flush as per Dwg D3562

OCT 15 2014

DAS

24

9-89

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

D

14-10-15

DAS

9

9-89

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre	780								
Material	24								
Operator	09.0								
Offset/Setup									
Process									
Supplier									
Training	130								
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
Bending	Bend	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld
Cuffs	Contamination	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled
Crushing	Countersink	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	
Heat Treat	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other
Inspection Strip in Tube	Drawing	<input type="checkbox"/>		<input type="checkbox"/>	
Marks/Chatter	Drill Holes	<input type="checkbox"/>		<input type="checkbox"/>	
Turning Sequence	Finish	<input type="checkbox"/>		<input type="checkbox"/>	
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>		<input type="checkbox"/>	

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Page 4

Item ID: D3562-041

Revision ID:

Item Name: Step Weldment

Start Date: 9/04/14 Start Qty: 4.00

Required Date: 9/04/14 Req'd Qty: 4.00

Reference:

Accept

Split

4
4

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on WO

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS

9

9-89

① 14-10-15

190

190

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

14-10-16

200

200

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

8:05

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320°

8:35

14-10-16 DAS 34.88

DOA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

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Item ID: D3562-041

Revision ID:

Item Name: Step Weldment

Start Date: 9/04/14 Start Qty: 4.00

Required Date: 9/04/14 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

210

210

HandFinish

Hand Finishing

Operation
Description

Wing Walk as per dwg QSI005 4.4 Batch W1302008

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

220

QC

Quality Control

QC3- Inspect Part Finish

0.00

DAS

38

9-89

14-10-16

230

230

Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

sh.p

DAS

06

9-89

OCT 15 2014

DQA:

Date:



QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced						
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up						
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure						
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld						
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled						
Crushing	Countersink	Misaligned/off center	Positioned Wrong							
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge							
Inspection Strip in Tube	Drawing	Misread								
Marks/Chatter	Drill Holes	Off-set								
Turning Sequence	Finish	Out of Calibration								
Wave/Twist in Tube	Fit/Function	Out of Sequence								

Work Order ID 123986

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Item ID: D3562-041

Revision ID:

Item Name: Step Weldment

Start Date: 9/04/14 Start Qty: 4.00

Required Date: 9/04/14 Req'd Qty: 4.00

Reference:

Accept

SPC

4
4

N900040100

Setup Start

NS1

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

240

OC21- Final Inspection - Work Order Release

240

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

MUJ 1410-17

Memo

0.00

W 4/10.17

DOA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____

DISPOSITION

AGAINST DEPARTMENT/PROCESS

 Rework
 Scrap
 Use-as-is
 Suspected Unapproved

 Skid-tube
 Machining
 Thermoforming
 Large Fab

 Crosstube
 Small Fab
 Finishing
 Composite

 Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

 Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread			
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set			
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence			

Picklist Print

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Page 1

Work Order ID: 123986

123986

Parent Item: D3562-041

D3562-041

Parent Item Name: Step Weldment

Start Date: 9/04/14

Required Date: 9/04/14

IPP Rev:A New Issue 06-11-09 JLM
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by:ec
IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
13.06.03 PER DWG REV.F DD VERE:JLM

Start Qty: 4.00

Start Qty: 4.00

Required Date: 9/04/14

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	115.0000	1	4	**		
D2622-120C												<i>DL 14-10-1</i>	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	111	
109575	32	
<u>119621</u>	79	
WA003	4	
101765	1	
115141	3	

140	Each	47.0000	2	8
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA003	47	
<u>119286</u>	35	<u>8</u>
119498	11	
99709	1	

140	Each	5.0000	1	4
-----	------	--------	---	---

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA003	5	
108798	1	
119472	4	

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

Picklist Print

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Work Order ID: 123986

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Parent Item: D3562-041

D3562-041

Parent Item Name: Step Weldment

Start Date: 9/04/14

Required Date: 9/04/14

D3560-043

Manufactured No

140

Each

4.0000

1

4

**

CPC14-10-15

D3560-043

Arm Weldment

Location Loc Qty Loc Code

WA003

4

119367

4

MS20600-AD4W5

Purchased No

160

Each

744.0000

32

128

**

CPC14-10-15

MS20600-AD4W5

Blind Rivet

Location Loc Qty Loc Code

ST310

372

m129820

372

WA003

372

m129472

372

DOA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

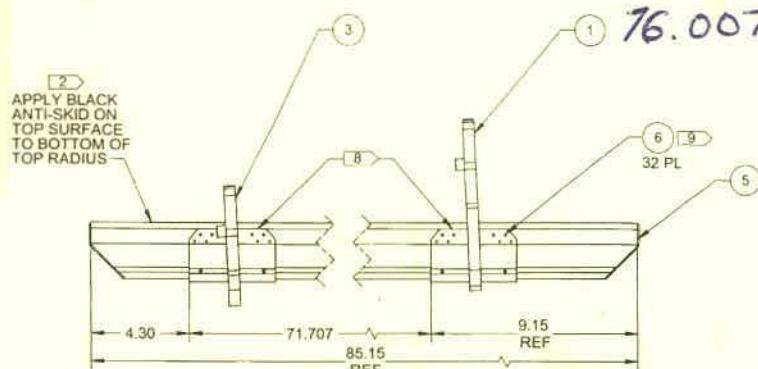
Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

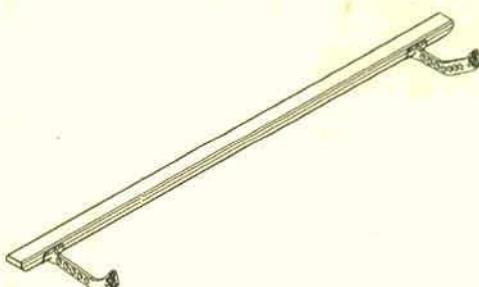
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>	
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>	
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>		
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>	
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>			
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>			
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>			
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>			



MEASURED BEFORE END CAPS WELDED IN PLACE



D3562-041 LH STEP ASSEMBLY

NOTES.

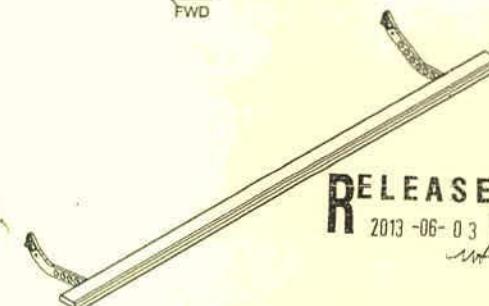
- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANTEX (4.3.5.6) OR
BLACK SANTEX (4.3.5.7) OR
GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING

1

ITEM No.	QTY 041	QTY 042	P/N	DESCRIPTION
	X		D3562-041	LH STEP ASSEMBLY
		X	D3562-042	RH STEP ASSEMBLY
1	1		D3560-041	ARM WELDMENT
2		1	D3560-042	ARM WELDMENT
3	1		D3560-043	ARM WELDMENT
4		1	D3560-044	ARM WELDMENT
5	1	1	D3562-1	STEP ASSEMBLY
6	32	32	MS.206.000AD4W	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123984 MCL

NO. 123986 M-LT
14-09-04



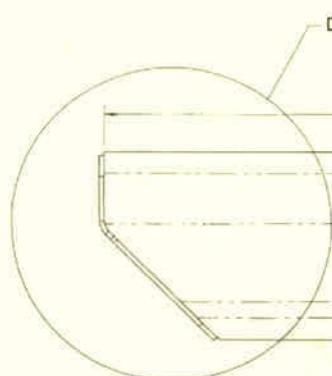
D3562-042 RH STEP ASSEMBLY

F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DF460, REF. PART12-224, ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY 2 TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE, REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV	DESCRIPTION	BY	DATE
DESIGN	<i>DP</i>	DART AEROSPACE LTD	
DRAWN	<i>DW</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DP</i>	DRAWING NO	REV. F
MFG APPR.	<i>NA</i>	D3562	SHEET 1 OF 2
APPROVED	<i>NA</i>	TITLE	SCALE
DE APPR	<i>NA</i>	STEP ASSEMBLY	
DATE	13.05.15	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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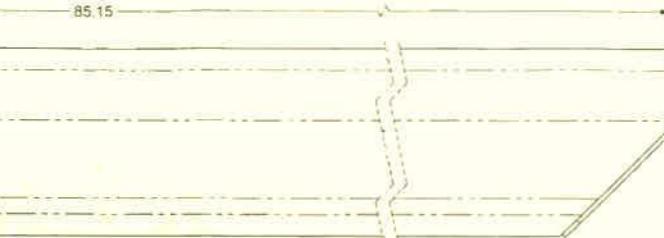
8 7 6 5 4 3 2 1

D



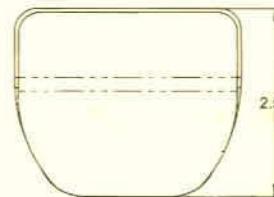
B4-2

85.15



C

2.51



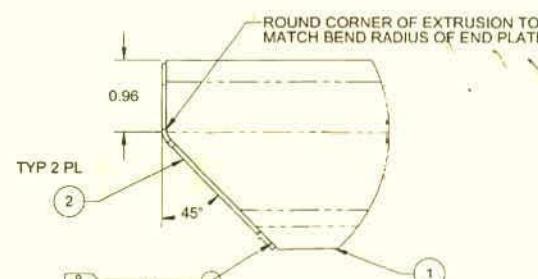
D

B

C

B

D3562-1 STEP ASSEMBLY



DETAIL A C7-2
TYP BOTH ENDS
SCALE 1X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.68 lbs
- 8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ITEM No.	QTY -1	P/N	DESCRIPTION
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE

DESIGN	40	DART AEROSPACE LTD
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA
CHECKED	NP	DRAWING NO.
MFG. APPR.		REV. F
APPROVED		D3562
DE APPR		SHEET 2 OF 2
DATE	13.05.15	TITLE
		STEP ASSEMBLY
		SCALE
		NTS

RELEASED
2013-06-03
NP

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